

Date: Thursday, 27/11/2008 2:37:46 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : R44 BEARPAW
Job Number : 43833	
Estimate Number : 12480	
P.O. Number :	Part Number : D35291
This Issue : 27/11/2008 S.O. No. :	Drawing Number : D3529 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 39667A	Material :
Written By :	Due Date : 04/12/2008 Qty: 2 Um: Each
Checked & Approved By : <u>JLD 08-11-27</u>	
Comment : Est Rev:A New Issue 06-06-28 JLM	
Est Rev:B New Manufacturing Method 08-11-27 Verified By:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 1.3283 sf(s)/Unit Total : 2.6565 sf(s)

Material: Black UHMW 1"(MUHMWB10)

Batch: 109186 IB 8-12-2

2.0	MFG ENGINEERING	MFG ENGINEERING
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Comment: MFG ENGINEERING  
 Program Batch Number

JLD 08-11-28

3.0	WATER JET	FLOW WATER JET
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IB 8-12-2(2)

Comment: FLOW WATER JET  
 CUT BLANK AS PER FILE D3529-1BLANK

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA645 and Dwg D3529

3-Deburr

JLD 09/01/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 BEARPAW

Job Number: 43833

Part Number: D35291

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IL 09/01/11

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 09/01/11 (2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: # 44704

MF 09-01-13

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/14 JF

Job Completion



MF 09-1-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 43833
<b>Description:</b> Bearpaw		<b>Part Number:</b> D3529-1
<b>Inspection Dwg:</b> D3529	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

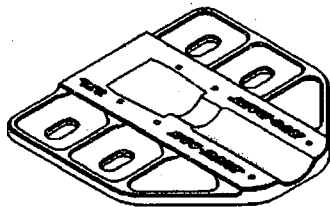
☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 5.50	+/-0.030	5.500	✓			
B 0.07 x 45°	+/-0.030 x 0.5°	.07x45°	✓			
C R0.25	+/-0.030	0.250	✓			
D 0.250	+/-0.010	.252	✓			
E 0.625	+/-0.010	.626	✓			
F 0.950	+/-0.010	.955	✓			
G 1.63	+/-0.030	1.625	✓			
H 12.14	+/-0.030	12.140	✓			
I						
J 5.70	+/-0.030	5.715	✓			
K 0.375	+/-0.010	.377	✓			
L 0.525	+/-0.010	.524	✓			
M 0.13 x 45°	+/-0.030 x 0.5°		?			
N R0.50	+/-0.030	0.500	✓			
O 12.76	+/-0.030	12.760	✓			
P 3.38	+/-0.030	3.379	✓			
Q 3.75	+/-0.030	3.751	✓			
R 5.187	+/-0.010	5.187	✓			
S 5.25	+/-0.030	5.247	✓			
T 7.13	+/-0.030	7.128	✓			
U Ø0.260	+0.006/-0.001	.260	✓			
V 0.30	+/-0.030	.310	✓			
W 0.93	+/-0.030	.925	✓			
X 1.30	+/-0.030	1.300	✓			

<b>Measured by:</b> J.L.	<b>Audited by:</b> J.F.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/01/11	<b>Date:</b> 09/01/11	<b>Date:</b>	N/A

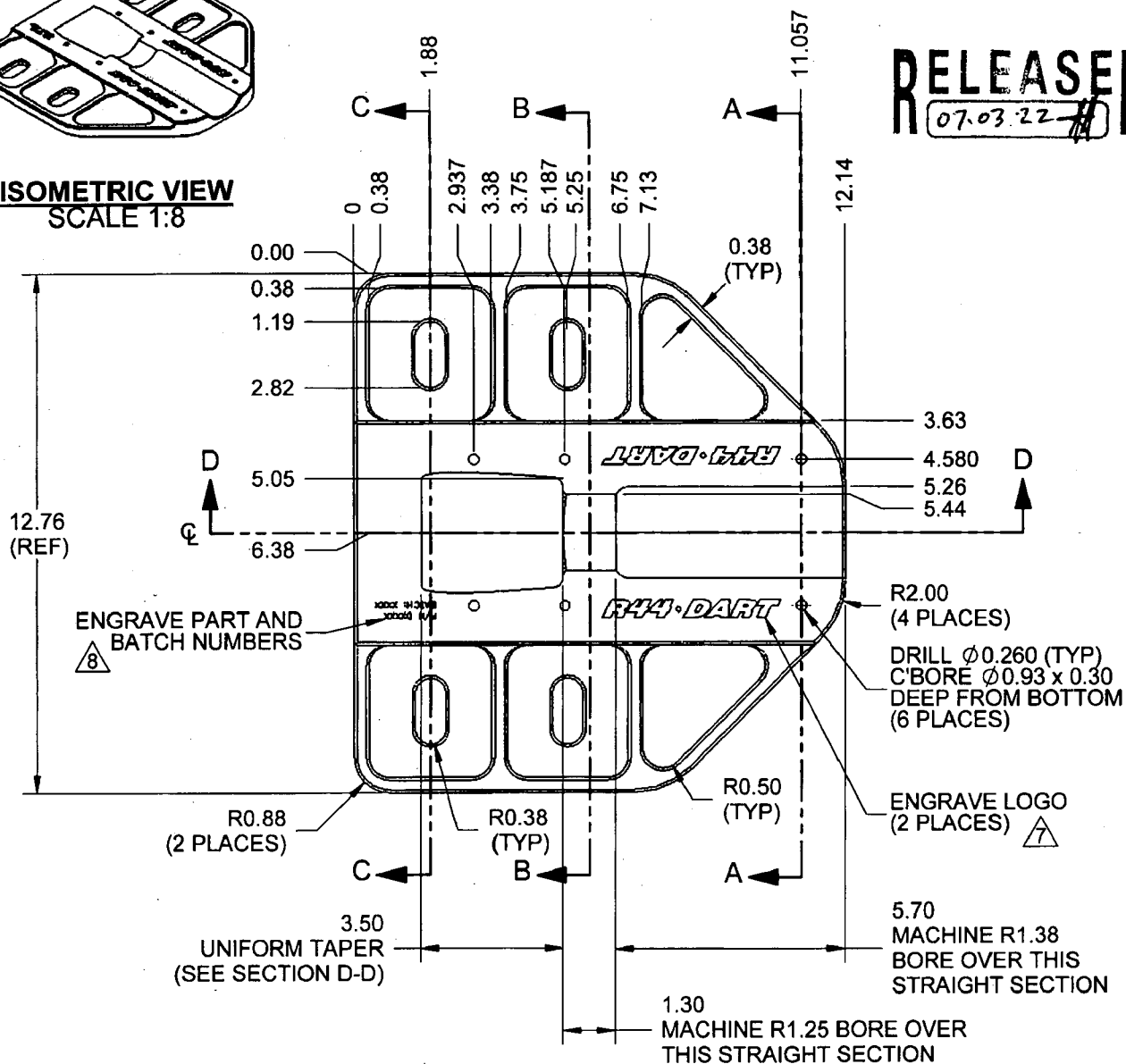
Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	
B	08.05.06	Dimension I removed	KJ/DD	

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3529	REV. A SHEET 1 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4
REV A	DATE 07.01.04	DESCRIPTION NEW ISSUE	



**ISOMETRIC VIEW**  
**SCALE 1:8**

RELEASED  
07.03.22



**D3529-1 R44 BEARPAW**

**NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)  
2) FINISH: NONE  
3) PART IS SYMMETRIC ABOUT C  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
5) ALL DIMENSIONS ARE IN INCHES  
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX  
7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN  
8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

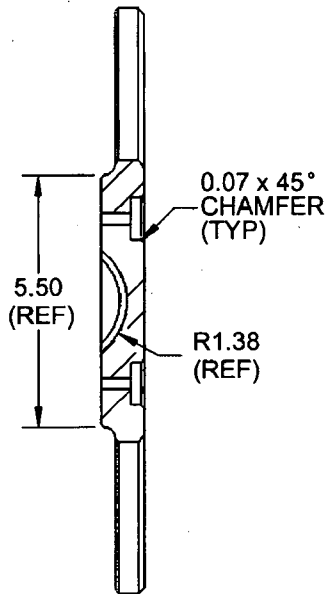
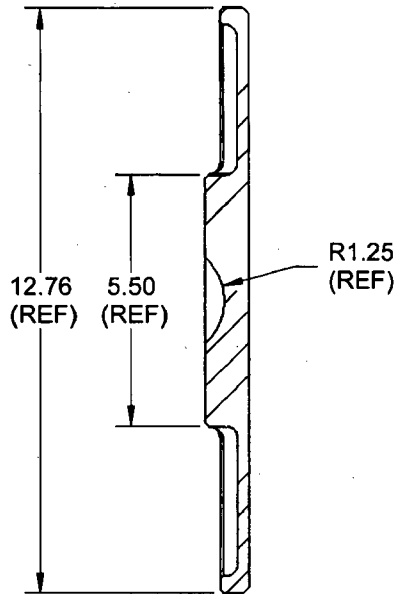
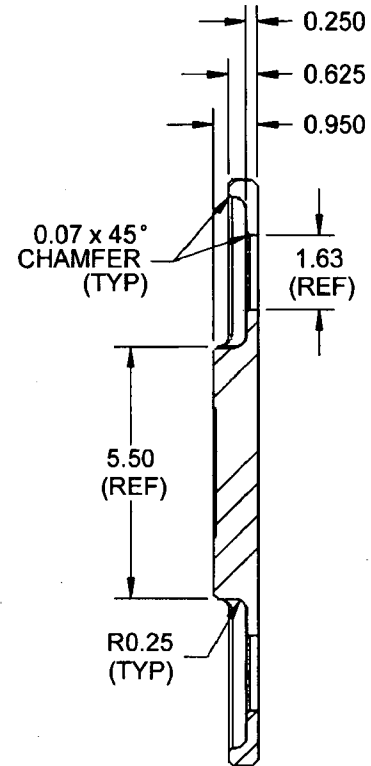
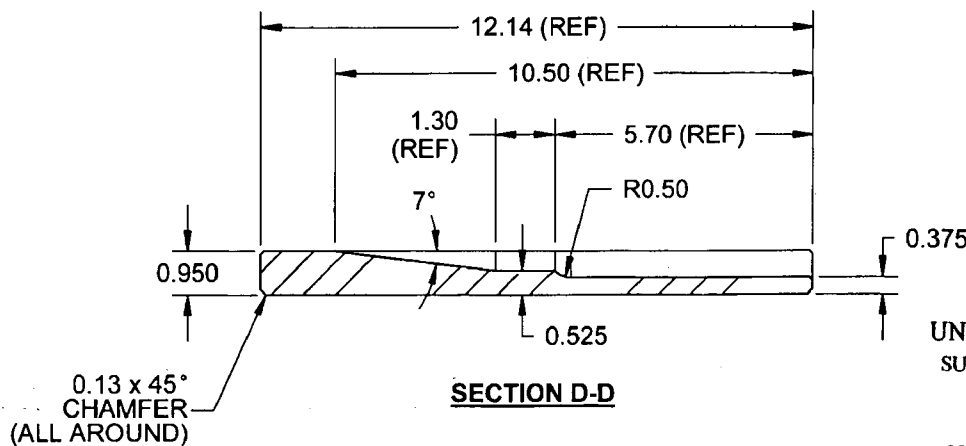
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WORK ORDER  
NO. 43833

**DART**

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3529	REV. A SHEET 2 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4

**RELEASED**  
07.03.22**SECTION A-A****SECTION B-B****SECTION C-C****SECTION D-D**

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